

Date: Tuesday, 19/08/2008 10:44:01 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE		
Job Number	: 41385 - 3	Part Number	: D37695		
Estimate Number	: 13374	Drawing Number	: D3769 REVA		
P.O. Number	:	Project Number	: N/A		
This Issue	: 19/08/2008 S.O. No. :	Drawing Revision	: A		
Prsht Rev.	: NC	Material	:		
First Issue	: 1/1 Type : SMALL /MED FAB	Due Date	: 20/08/2008	Qty:	20 Um: Each
Previous Run	: 40977				
Written By	:				
Checked & Approved By	: MF 08-08-19				
Comment	: Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 1.7579 f(s)/Unit Total: 35.1582 f(s)
 6061T6 TUBE (1.00" x 0.65" wall)
 batch: M107000

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3769

08/08/26

18X

2-drill holes thru on both ends of tube as per dwg D3769

3- deburr

FF 08/09/16 4

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

So 08/09/16 44

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. 08/09/17

4X

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/09/17 4



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 41385

Part Number: D37695

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

used on D3783-045
B#40876

FF 08/09/17

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-17

8 7 6 5 4 3 2 1

D

D

C

C

B

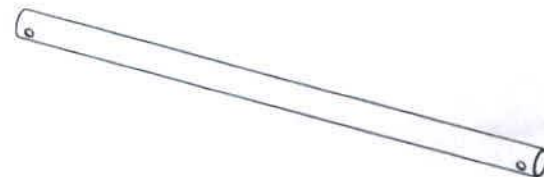
B



D3769-1 TUBE



D3769-3 TUBE



D3769-5 TUBE

#41308

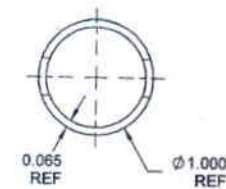
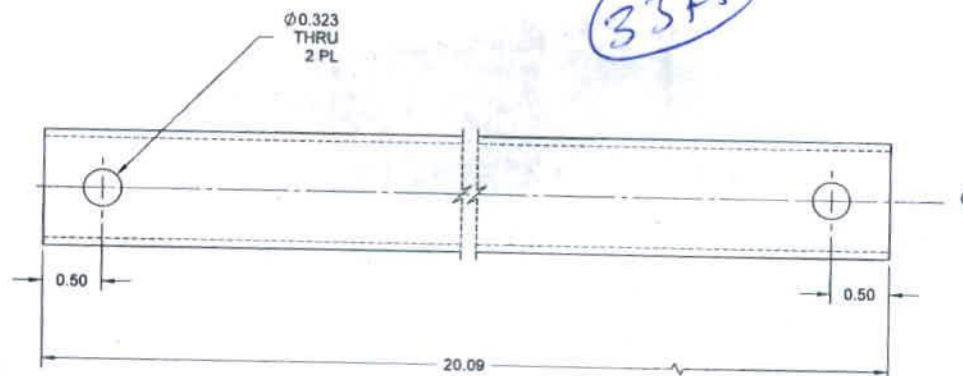
RELEASED
08.06.15/10

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
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DE APPR.	<i>[Signature]</i>	TUBE	NTS
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8 7 6 5 4 3 2 1



D3769-5 TUBE

41385

RELEASED
08-06-16 1.07

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DRAWN	HS		
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